



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

3

D3391-025
Job Sheet 167283-B



Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Sold Alone

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 12/18/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Customer: Falcon Aviation Services (CFALC01)

PO Box 62030 Abu Dhabi, United Arab Emirates ph:011 971 50 445 0187 fx:+971 2 444 0022.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/15/17	0.00	0.00	Start Up Skid tubes		
100	Mori Seiki	1 pcs		12/15/17	2.49	4.17	Mori Seiki TL-40		PMP
110	QC	1 pcs		12/15/17	0.00	0.00	QC2		PMP
112	QC	1 pcs		12/15/17	0.00	0.00	QC5		17.11.13
120	CNC Vertical Machining	1 pcs		12/16/17	0.00	2.63	HAAS 1		K+ 17-12-03
130	QC	1 pcs		12/16/17	0.00	0.00	QC2		K+ 17-12-03
140	QC	1 pcs		12/16/17	0.00	0.00	QC8		9/17/12/04
150	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		MLG
160	CNC Bend Skid tubes	1 pcs		12/16/17	0.00	1.33	CNC Bend Skid tube		MLG
170	QC	1 pcs		12/16/17	0.00	0.00	QC5		BE
180	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		MLG DAS
190	QC	1 pcs		12/16/17	0.00	0.00	QC5		38
200	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish1		2017-12-19
210	QC	1 pcs		12/16/17	0.00	0.00	QC7		AK 17-12-21
220	Skid tubes	1 pcs		12/16/17	0.00	1.41	Skid tubes		AP 2017/12/20
230	QC	1 pcs		12/16/17	0.00	0.00	QC5		AK 17-12-21
235	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish2		2017-12-21
240	Spray Paint	1 pcs		12/16/17	0.00	0.25	Spray Paint		PO 038090
250	QC	1 pcs		12/16/17	0.00	0.00	QC14		HL 17-12-27
260	HandFinish	1 pcs		12/18/17	0.00	0.58	HandFinish4		DE (DAS) 12/28
270	QC	1 pcs		12/18/17	0.00	0.00	QC5		38
280	Packaging	1 pcs		12/18/17	0.00	0.00	Packaging3		3-88
290	QC21-SA	1 Ea		12/18/17	0.00	0.00	QC21		

Part Op 100 - Turn as per Folio FA599 Rev: AK & Dwg D3391 Rev: 5 ***ensure steady rest is turning true*** **REMOVE
Descriptions: STEADY REST AND MACHINIG MARKS****

120 - 1-Machine as per Folio FA 599 Rev: AK & Dwg D3391 Rev: 5

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391 (Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end

DART
AEROSPACE
S008529

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Hawkesbury, ON K64 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



Aft Tube Assembly

PART NO: D3391 - 025

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 11/09/17

Job No: 167283 - B

3

220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: M137712 exp. date: 2018/01 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Debur

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3

260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 _____

Sikaflex expiry date: _____ 3- INSTALL WEARPLATES AS PER DWG

290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink.

6-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Debur 9- Scribe batch # on fwd end

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6014-090 <u>F139427</u>	1	42	0	0
220-Skidtubes	D3670-4-200 <u>B165393</u>	4	79	0	0
260-HandFinish	ALS4-1032-130 <u>S007271</u>	8	1,343	0	0
	D4095-047 <u>F164735</u>	1	20	0	0
	D4095-049	1	30	0	0
	MS20601-AD4W3 <u>S016824</u>	12	150	0	0
	MS20601-AD4W7 <u>B137148</u>	8	313	0	0
	MS21075L5 <u>F138042</u>	10	173	0	0
270-QC <u>F135998-2</u>	ALS4-1032-225	4	897	0	0
	AN3C4A <u>S000533</u>	6	1,670	0	0
	AN3C5A <u>S019396</u>	4	364	0	0
	D2646 <u>F164005</u>	1	151	0	0
	D3672-1 <u>F150074</u>	2	1,777	0	0
	NAS1149C0332R	10	4,758	0	0
	<u>F138404-1</u>				

Part Specifications

Specifications could not be found.

Plex 10/27/17 2:29 PM dart.Michaud-Febrille.Victoria

OP 100 D6014-090 B139427

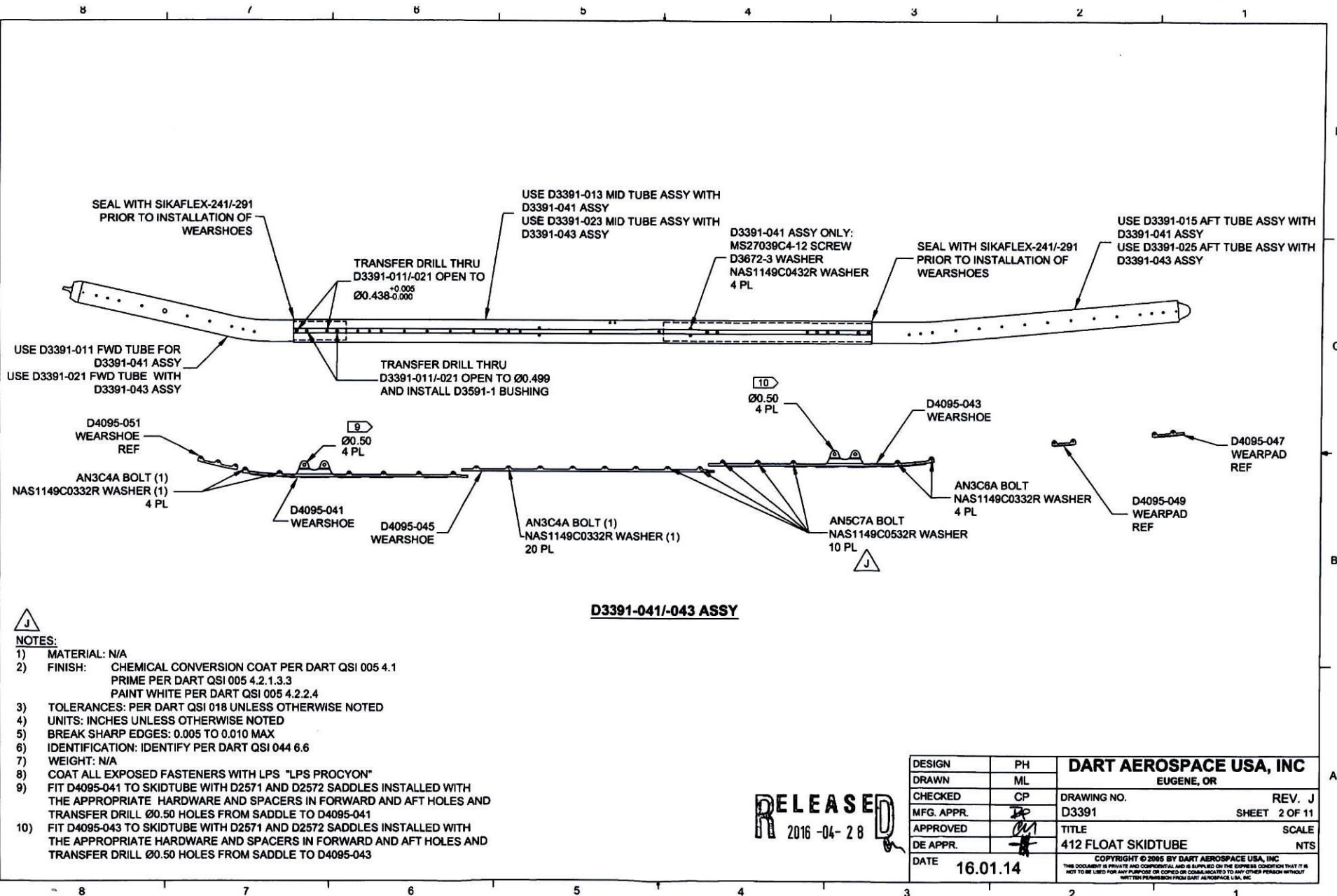
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

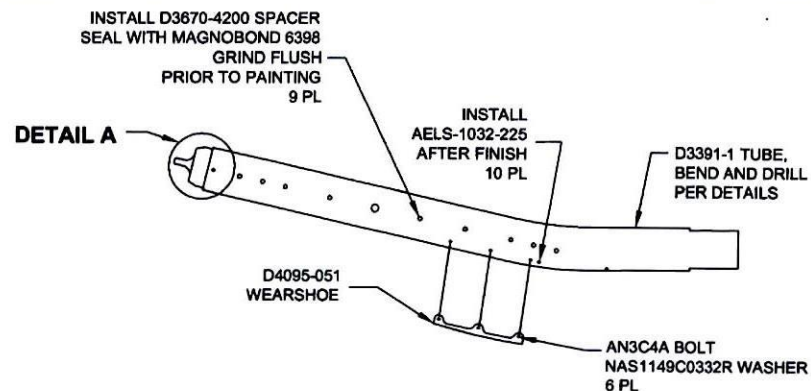
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C8A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER

J

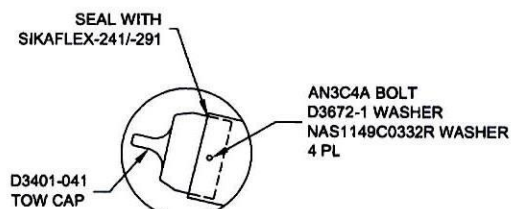
J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B8-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
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2016-04-28
ECN 16-96

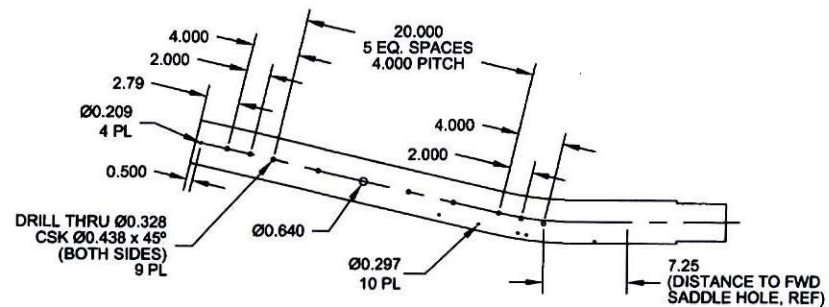




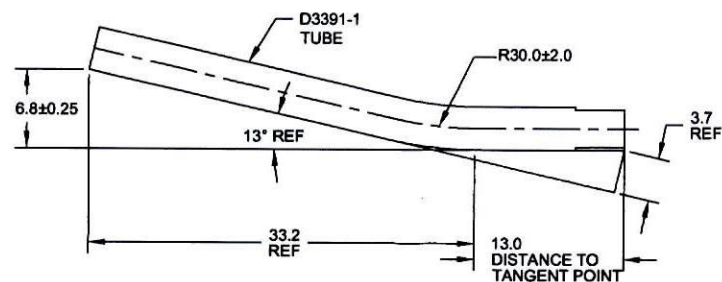
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 3 OF 11
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2016-04-28

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



INSTALL
AELS-1032-225
AFTER FINISH
10 PL

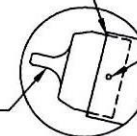
D4095-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

D3401-041
TOW CAP

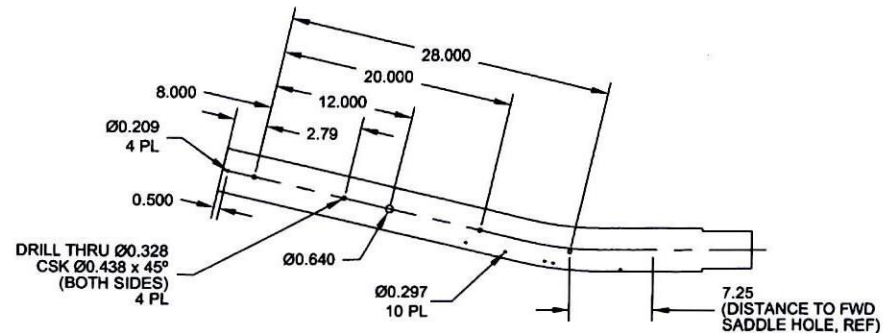


AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

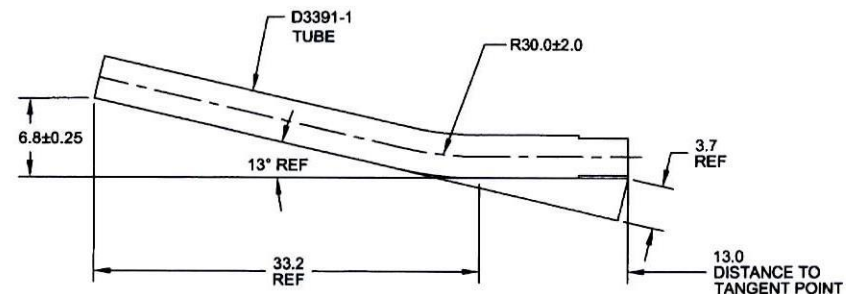
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



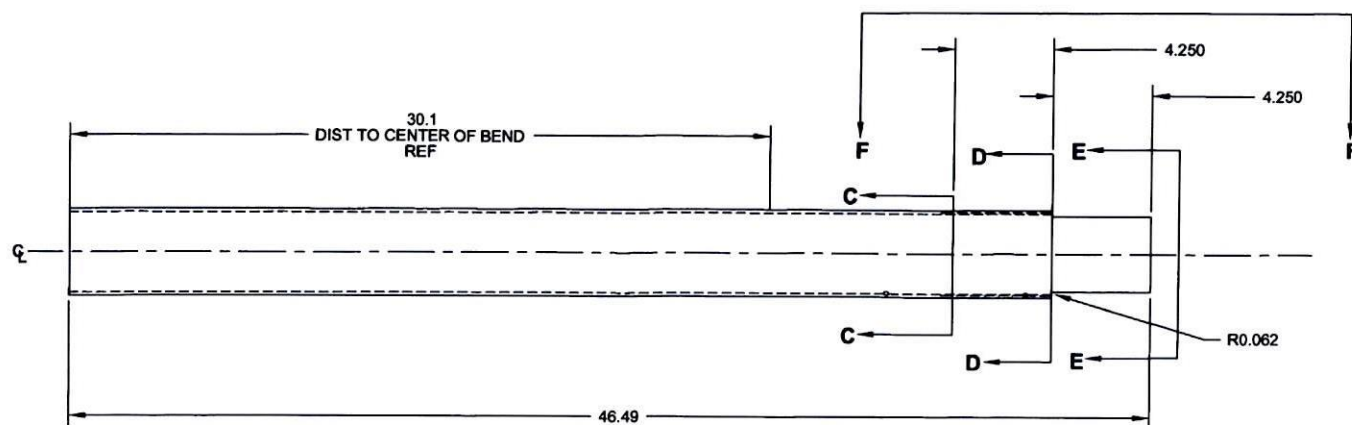
D3391-021 DRILLING DETAIL



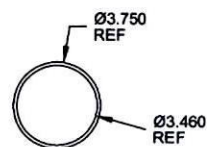
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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2016-04-28

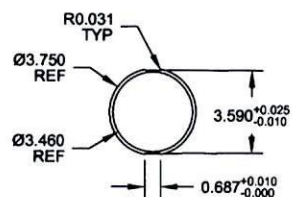
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DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
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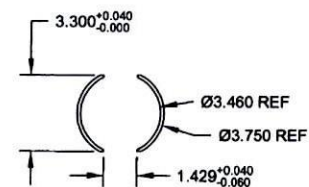
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



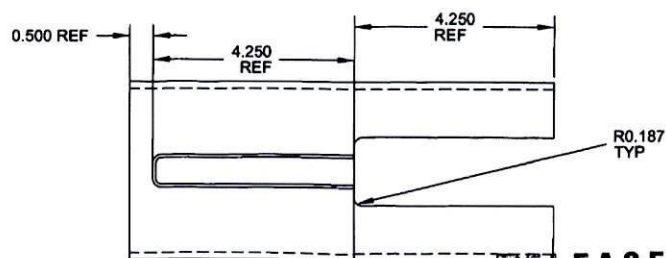
SECTION C-C



SECTION D-D



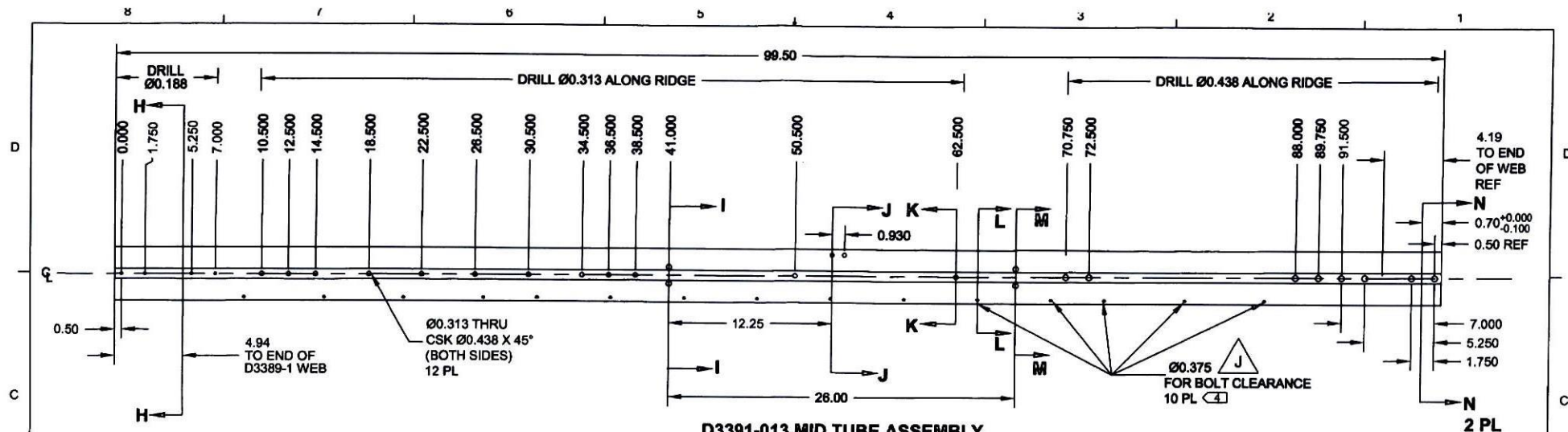
SECTION E-E



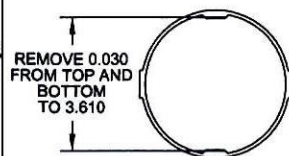
VIEW F-F
SCALE 2X

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2016-04-28

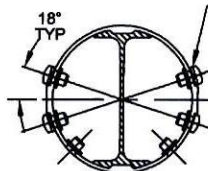
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CHECKED	CP	DRAWING NO.	REV. J
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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D3391-013 MID TUBE ASSEMBLY

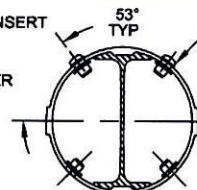


SECTION H-H
SCALE 2X



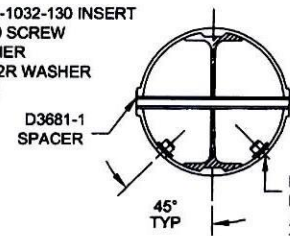
SECTION I-I
SCALE 2X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
NAS1149C0432R WASHER
AFTER FINISH
4 PL



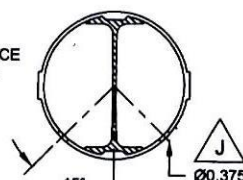
SECTION J-J
SCALE 2X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
NAS1149C0332R WASHER
AFTER FINISH
4 PL



SECTION K-K
SCALE 2X

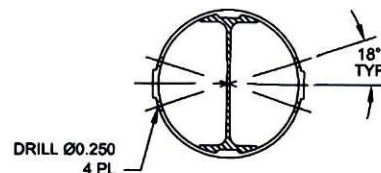
WELD INTO PLACE
& GRIND FLUSH
(BOTH ENDS)
12 PL



SECTION L-L
SCALE 2X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
-013		
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER

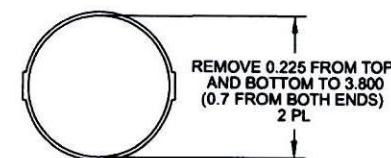


SECTION M-M
SCALE 2X



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

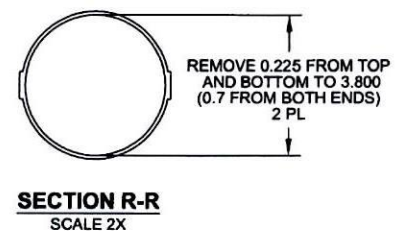
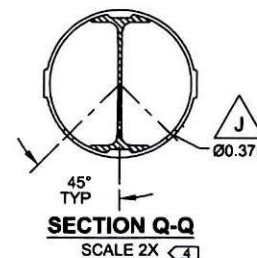
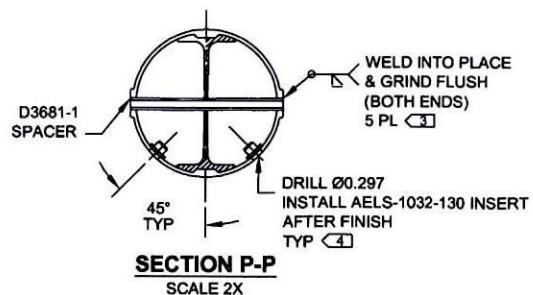
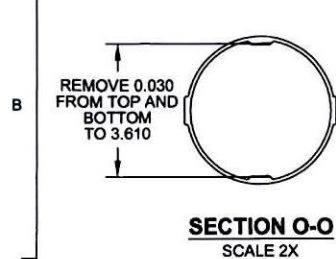
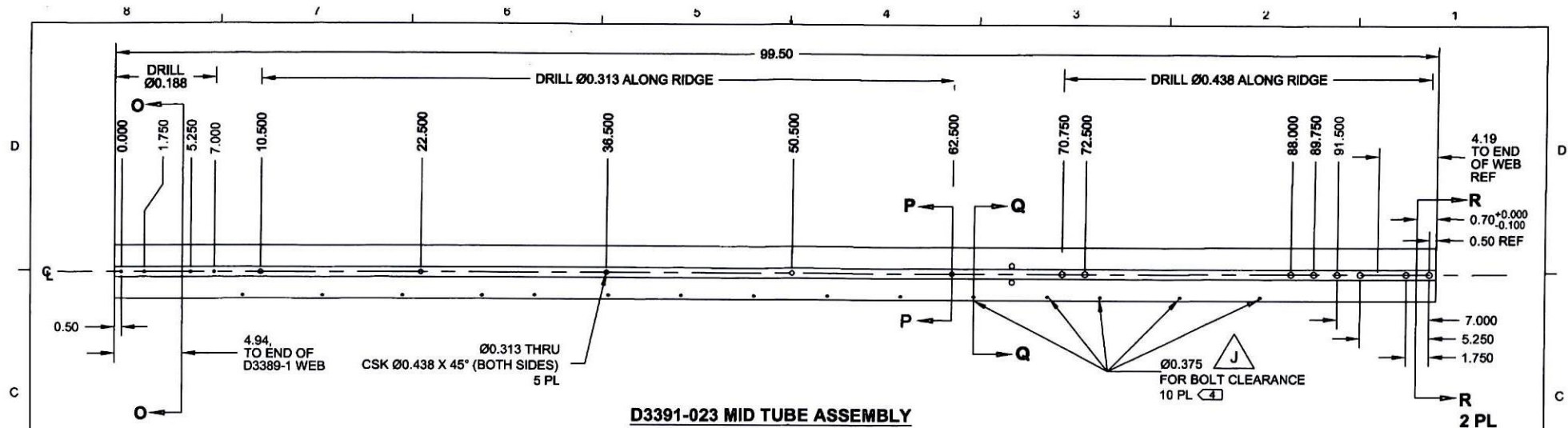


SECTION N-N
SCALE 2X

DESIGN	PH
DRAWN	ML
CHECKED	CP
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	16.01.14

DART AEROSPACE USA, INC	
EUGENE, OR	
DRAWING NO.	REV. J
D3391	SHEET 6 OF 11
TITLE	SCALE
412 FLOAT SKIDTUBE	NTS
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2016-04-28



D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

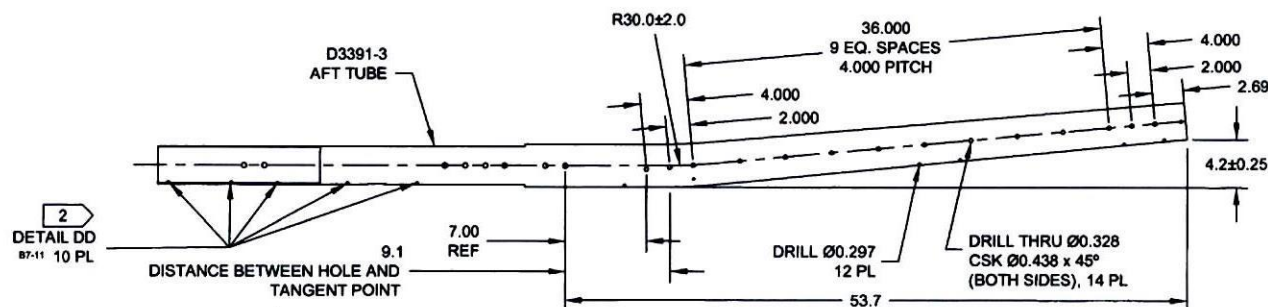
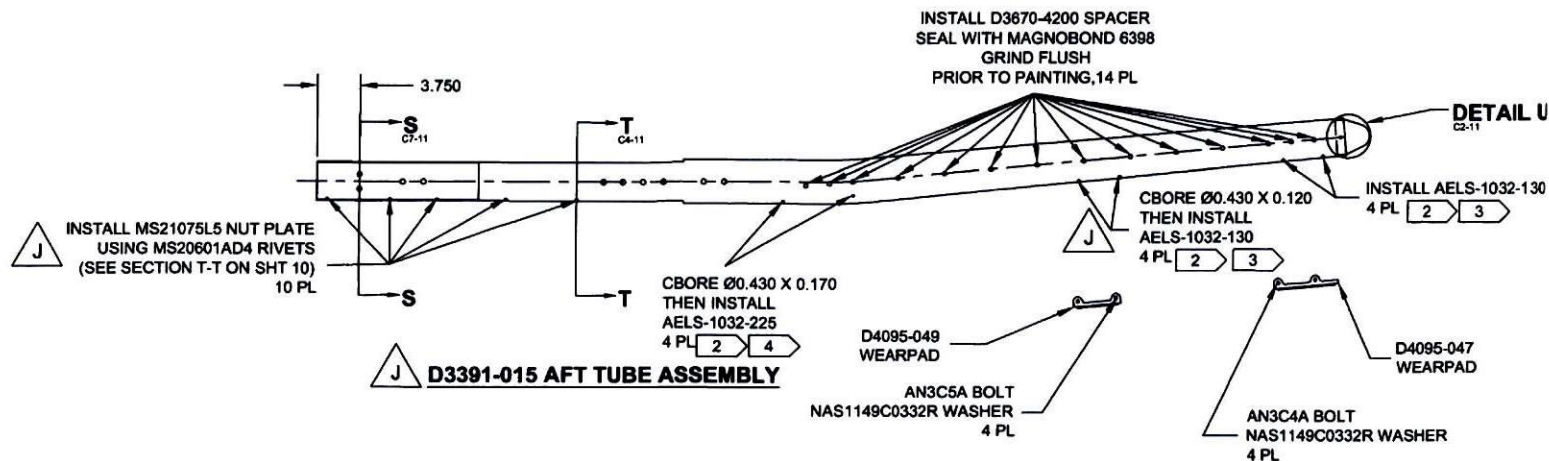


D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES, CBOR AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>CP</i>	D3391	SHEET 7 OF 11
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>CP</i>	412 FLOAT SKIDTUBE	NTS
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D3391-015 AFT TUBE ASSEMBLY PARTS LIST

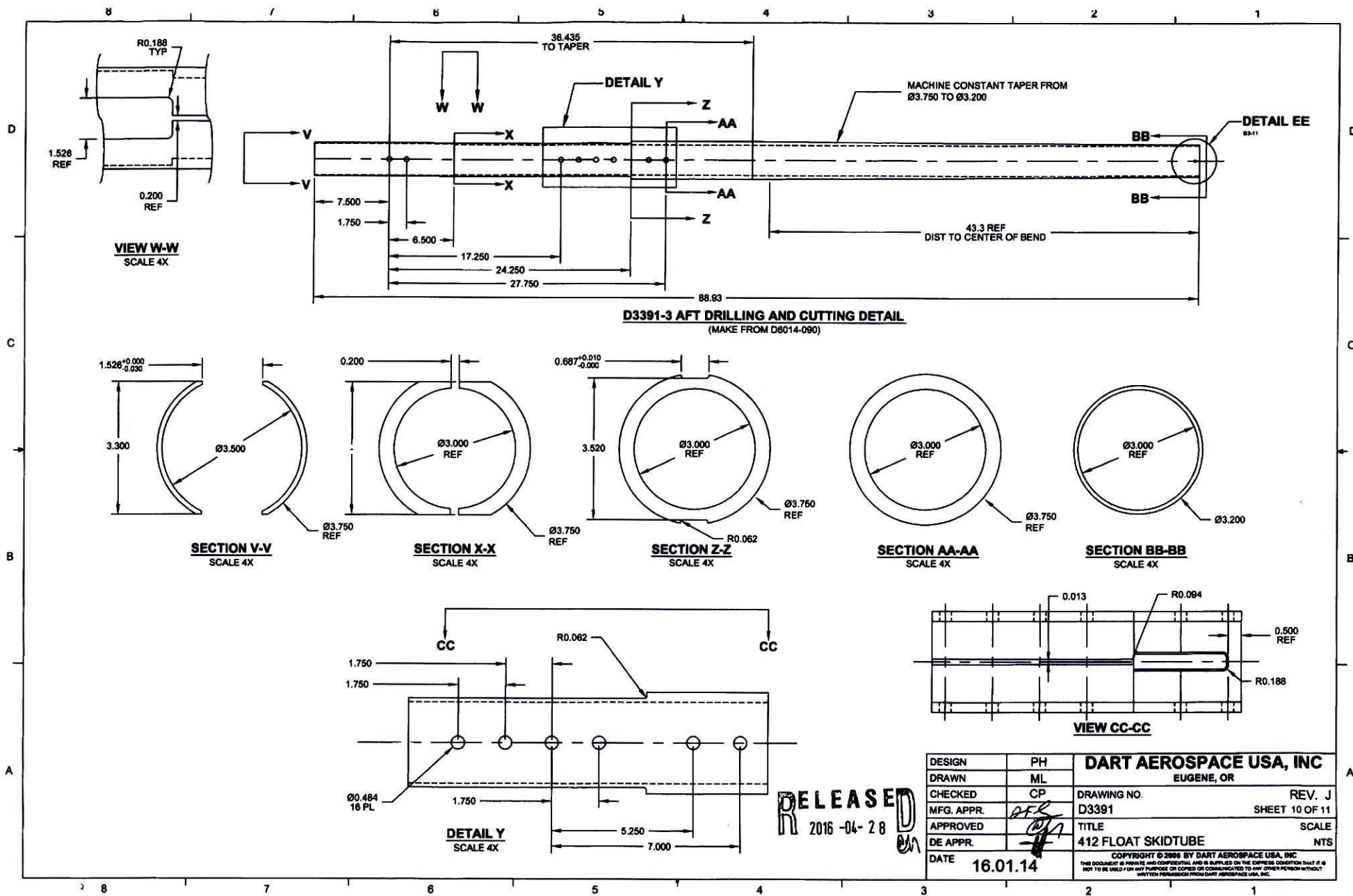
QTY	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	ALS4-428-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

NOTES:

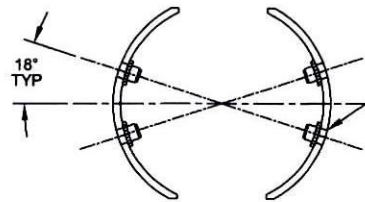
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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MFG. APPR.		D3391	SHEET 8 OF 11
APPROVED	<i>Re</i>	TITLE	SCALE
DE APPR.	<i>Ph</i>	412 FLOAT SKIDTUBE	NTS
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MFG. APPR.	<i>[Signature]</i>	D3391	SHEET 10 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	412 FLOAT SKIDTUBE	NTS
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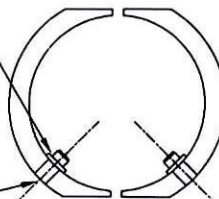


SECTION S-S
SCALE 5X

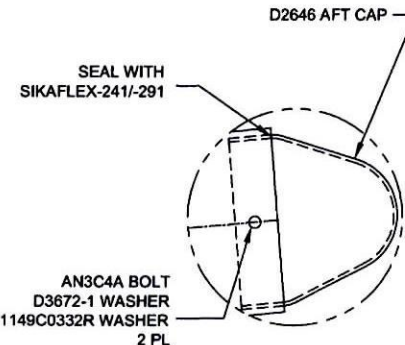
DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL

USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO Ø0.375

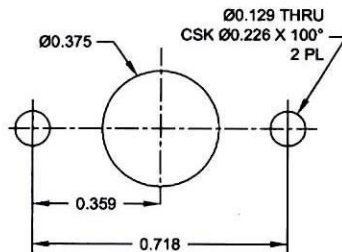
MS21075L5 NUTPLATE
REF



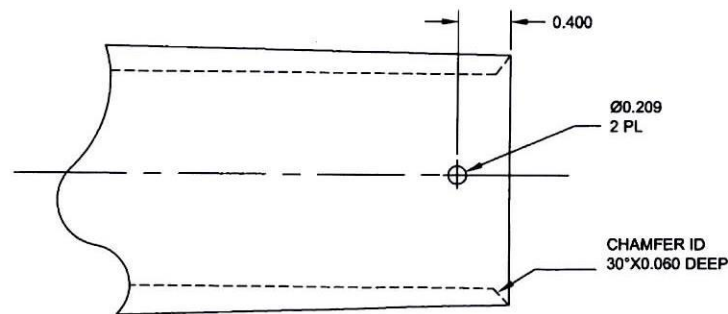
SECTION T-T
SCALE 5X
5 PL



DETAIL U
SCALE 5X



DRILLING DETAIL DD
SCALE 10X



DETAIL EE
SCALE 2X

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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MFG. APPR.	YR	D3391	SHEET 11 OF 11
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	AFT TUBE ASSEMBLY	NTS
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DART AEROSPACE LTD		Work Order: 167 283-B
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.0	✓		TAPE	
3.500	+/-0.010	3.503	✓		VERN 08	
Ø3.200	+/-0.010	3.199	✓			
Ø3.750	+/-0.010	3.749	✓			
30° x 0.060 chamfer	+/-0.010	.075	✓		↓	
88.93	+/-0.030	88.920	✓		TAPE	

Measured by: PMP PMP	Date: 2017-11-03
Audited by: PD	Date: 17.11.13

HAAS Section						
1.526	+0.000/-0.030	1.512	✓		Kt-05	vern
7.500	+/-0.010	7.500	✓		" "	" "
27.750	+/-0.010	21.750	✓		TAPE	—
31.750	+/-0.010	31.750	✓		" "	—
35.250	+/-0.010	32.250	✓		" "	—
3.300	+/-0.010	3.300	✓		Kt-05	vern
0.200	+/-0.010	0.200	✓		" "	" "
3.520	+/-0.010	3.520	✓		AG-10	micro
0.687	+0.010/-0.000	0.689	✓		Kt-05	vern.
R0.062	+/-0.010	0.0625	✓		R-G	—
Ø0.484	+0.005/-0.001	0.486	✓		Kt-05	vern.

Measured by: DAS 1KA- DAS	Date: 17-12-03
Audited by: 9-89 14 9/12	Date: 17/12/04

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

